

# Work Order ID 52577

October 2, 2009 8:41:38 AM



Page 1

Item ID: D2066

Accept



Setup Start



Revision ID: C

Stop



Item Name: Arm

Start Date: 02/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date: 09-10-2

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2066

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

*[Signature]*

1-Punch 1/2" OD x .093" Wall 304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727) Use punch Jig DT8012 Slide on parts per Dwg and W/O for D2676-043 Punch other end to length (28.62") as per Dwg D2066 4-Bend per Dwg D2066 5-Drill

*[Signature]* 09/11/23

10X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*[Signature]*

10X

120

Identify as per dwg & Sock Location:

0.00



Packaging

Memo

0.00

Packaging

9/11/24 100 50

**Work Order ID 52577**

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Item ID: D2066

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Setup Start



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Stop



Item Name: Arm

Start Date: 02/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 12/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

BL 09-11-24

(10)

# Picklist Print

Page 1

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Work Order ID: 52577

Parent Item: D2066RevC

Parent Item Name: Arm


Comments:

Start Date: 02/10/2009

Required Date: 12/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10  Washer		Purchased	No			100	Each	1,958.000	40.0000			

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1958	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369 ✓	567	

*M-L 09/11/19*

*40X*

D2052RevD



Mounting Bracket

Manufactured No

100 Each 37.0000 20.0000

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	37	
39556	5	
47596 ✓	32	

*M-L 09/11/19*

*20X*

# Picklist Print

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October 2, 2009 8:41:37 AM

Work Order ID: 52577

Parent Item: D2066RevC

Parent Item Name: Arm



Comments:

Start Date: 02/10/2009

Required Date: 12/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2054RevB  Bushing		Manufactured	No			100	Each	24.0000	20.0000 			<del>X</del>

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

39433

24

D2055RevC1

Manufactured

No



Clamp

100

Each

35.0000

10.0000  


~~20X~~

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

34365

5

47562 ✓

30

D2056RevB2

Manufactured

No



Bell Crank

100

Each

20.0000

10.0000  


~~10X~~

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

51429 ✓

20

~~10X~~

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Shop Packet Print

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# Picklist Print

Page 3

October 2, 2009 8:41:37 AM

Work Order ID: 52577



Parent Item: D2066RevC



Parent Item Name: Arm

Start Date: 02/10/2009

Required Date: 12/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3		Purchased	No			100	Each	3,579.000	20.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Nut

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	3579	
	110844	32	
	111274	55	
	111668	992	
	112314	2000	
	112385	500	

M-L 09/11/19

20X

MS27039-1-18		Purchased	No			100	Each	84.0000	20.0000			
--------------	--	-----------	----	--	--	-----	------	---------	---------	--	--	--



Screw

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	84	
	110916	84	

M-L 09/11/19

20X

M304TR0.500W.049		Purchased	No			120	f	125.5858	25.1158			
------------------	--	-----------	----	--	--	-----	---	----------	---------	--	--	--



304 RD Tube .500 x .049W

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	MAT	125.5857895	
	111814	125.58579	

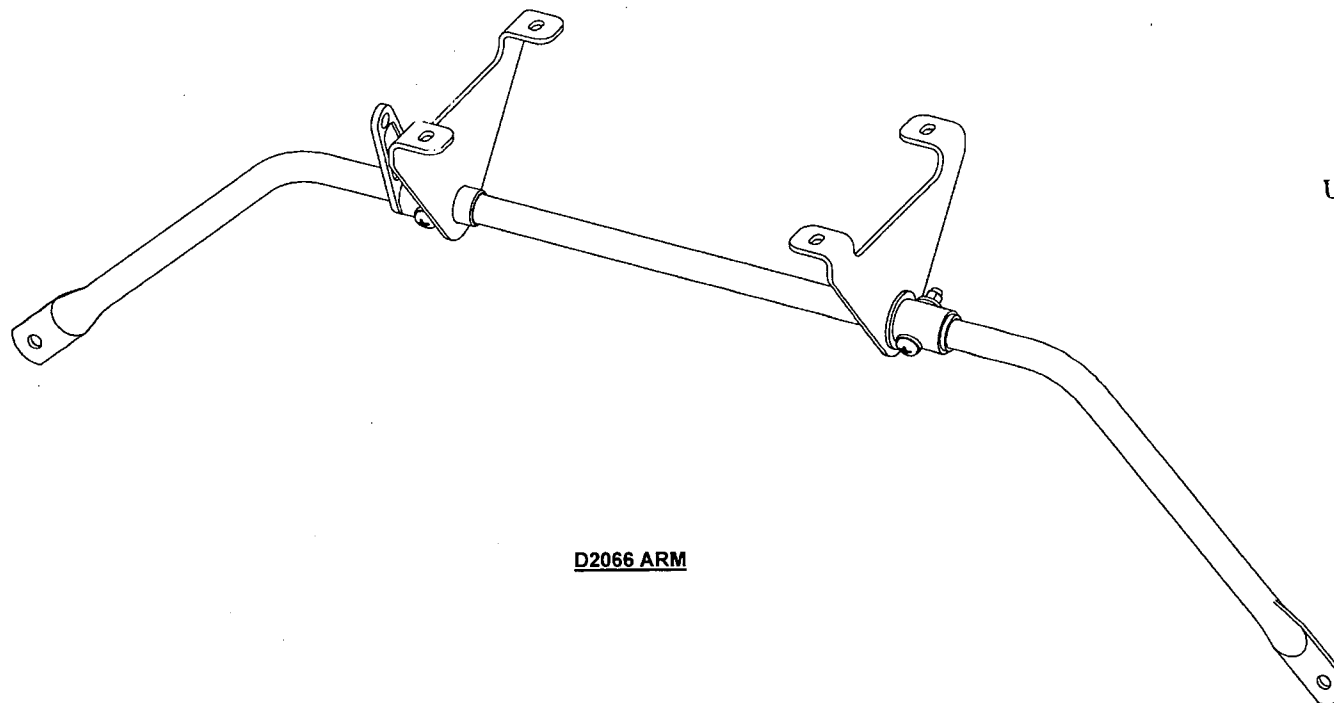
M-L 09/11/18

25.1158

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Shop Packet Print

Page 3



**D2066 ARM**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52577  
*BS 09-10-2*

**RELEASED**  
*09-07-15-10*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PL</i>		
CHECKED	<i>3</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>32</i>	<b>D2066</b>	SHEET 1 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>ARM</b>	NTS
DATE	08.06.12	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

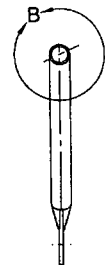
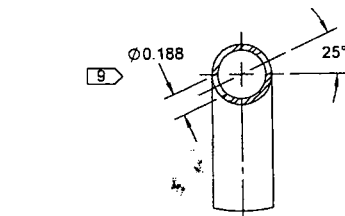
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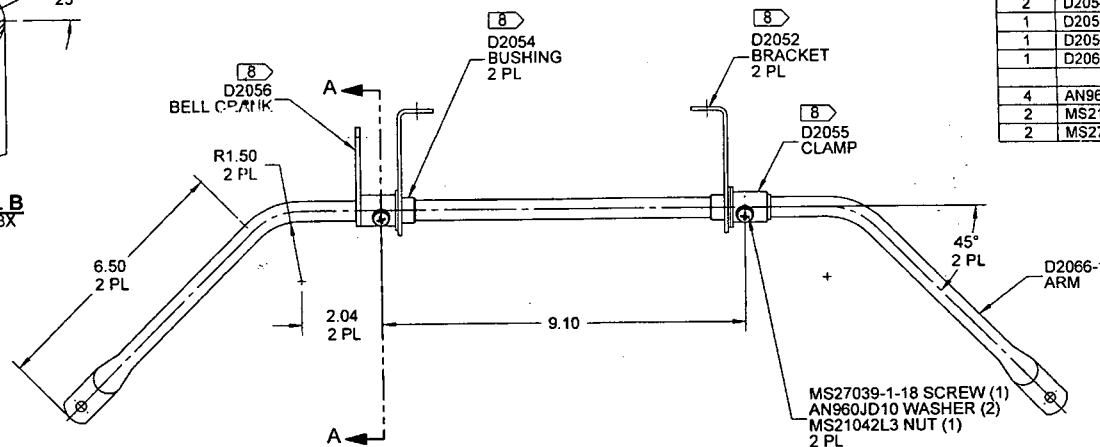
1

QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW



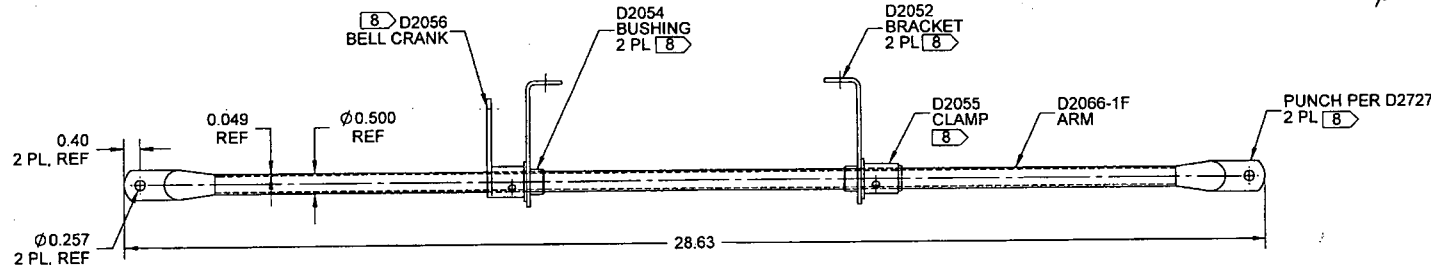
### SECTION A-A

(SOME PARTS REMOVED FOR CLARITY)



**D2066-1 ARM BENDING DETAIL**

(MAKE FROM D2066-1F)



**D2066-1F ARM CUT LENGTH DETAIL**

### NOTES:

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL   
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM  
AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL  $\phi 0.188$  AFTER BENDING

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52577  
PA 09-10-2

RELEASED  
08-07-18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2066	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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